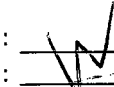


Date: Wednesday, 13/02/2008 1:18:36 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ANGLE
Job Number	: 37400		
Estimate Number	: 13168		
P.O. Number	:	Part Number	: D37411
This Issue	: 13/02/2008 S.O. No. :	Drawing Number	: D3741 U/R
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: U/R
Previous Run	: 37307	Material	:
Written By	: 	Due Date	: 13/02/2008
Checked & Approved By	:	Qty:	10 Um: Each
Comment	: Est Rev:A 08-01-30 new issue DD verified by:		



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6207	Angle Extrusion 1x1x.125
-----	-------	--------------------------



Comment: Qty.: 0.0656 f(s)/Unit Total : 0.6563 f(s)

D6207 angle extrusion

Batch: ~~1113905~~ ~~B37395~~ B27538

2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: 1- Mill as per dwg D3741

2-Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



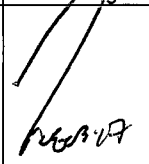
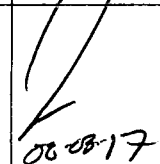
Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Grind radius as per dwg D3741

2- Deburr if necessary

08.02.14 10
 08.02.14/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.02.14	5b.	add 2 Steps, Alodine Step and inspection Step after Step 5 permanent change	SAH	08.02.14			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/02/2008 1:18:37 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 37400

Part Number: D37411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: UHA

08.03.10

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/17

Job Completion



U 08.02.27

POSITIVE RECALL

OBJECTIVE 08.02.13 AUTH U

RELEASED ADS DATE 08.03.17

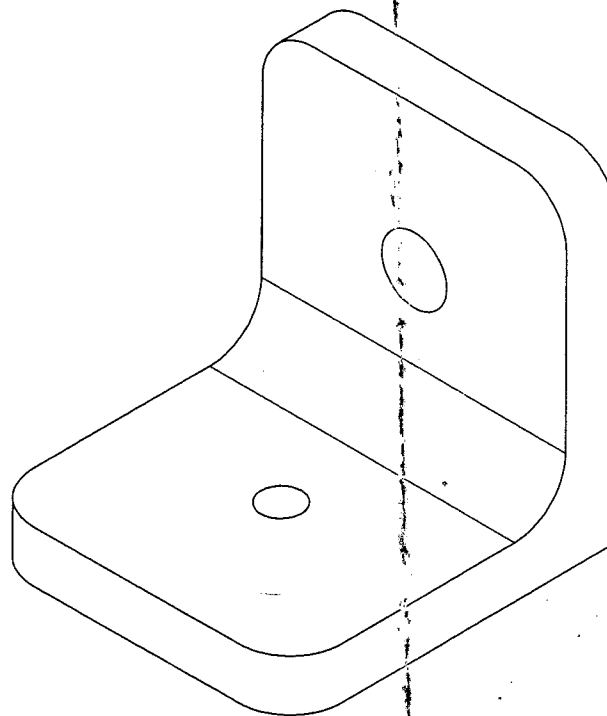
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



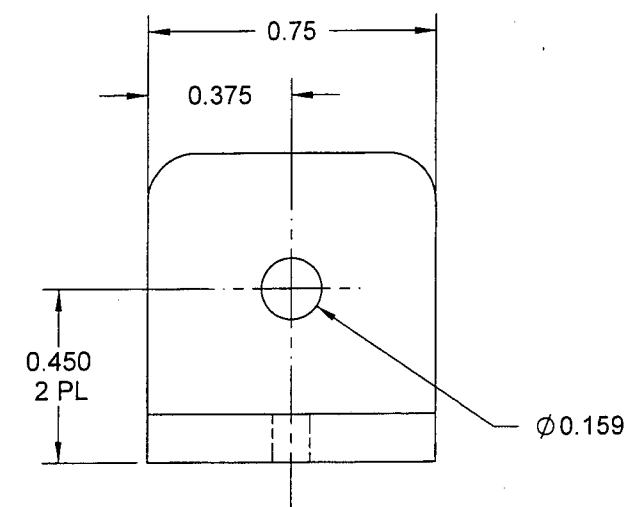
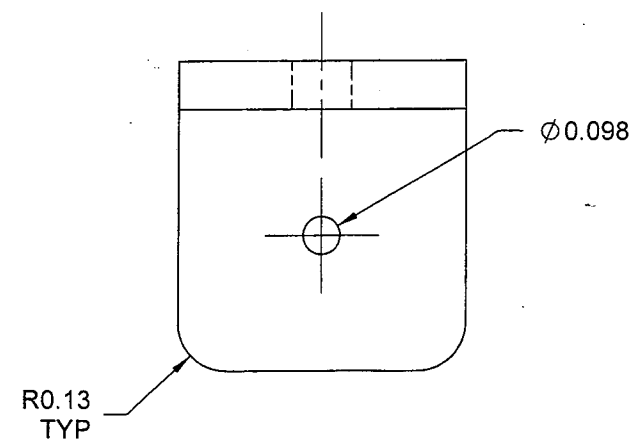
PRELIMINARY ISSUE

NOTES:

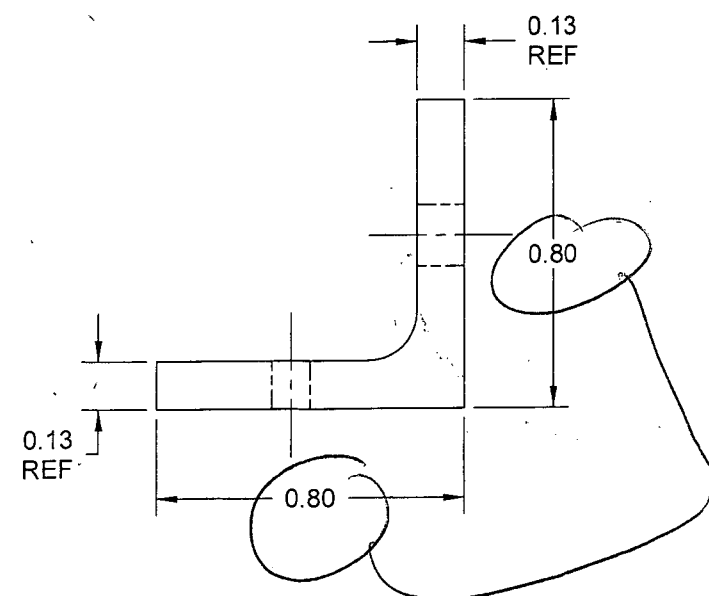
- 1) MATERIAL: MAKE FROM D6207 OR D6203 EXTRUSION
- 2) FINISH: ~~None~~ *Chemical Conversion Coat.*
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

NOT A
GOOD IDEA

A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	<i>UE</i>	DRAWING NO. D3741		REV. A
MFG. APPR.				SHEET 1 OF 2
APPROVED		TITLE ANGLE		SCALE
DE APPR.				NTS
DATE	08.02.04		COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



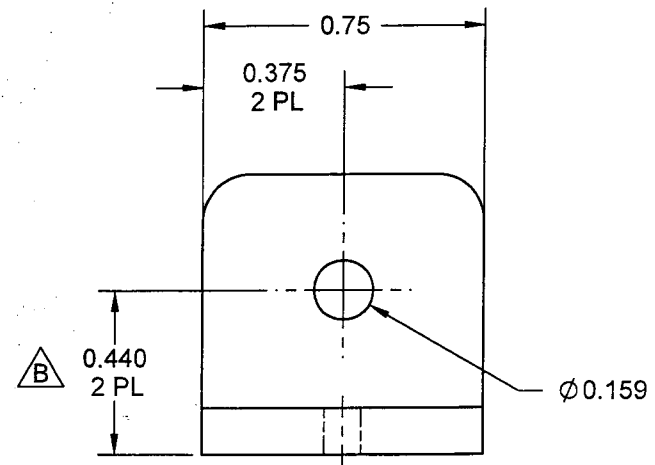
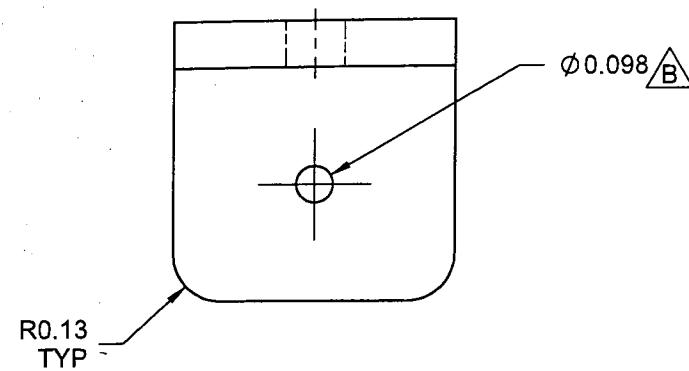
D3741-1 ANGLE



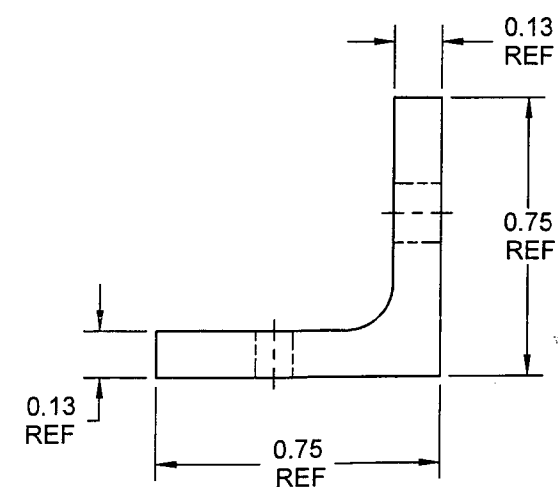
PRELIMINARY ISSUE

*COSTLY TO
DRUM AN
ANGLE ISN'T IT?*

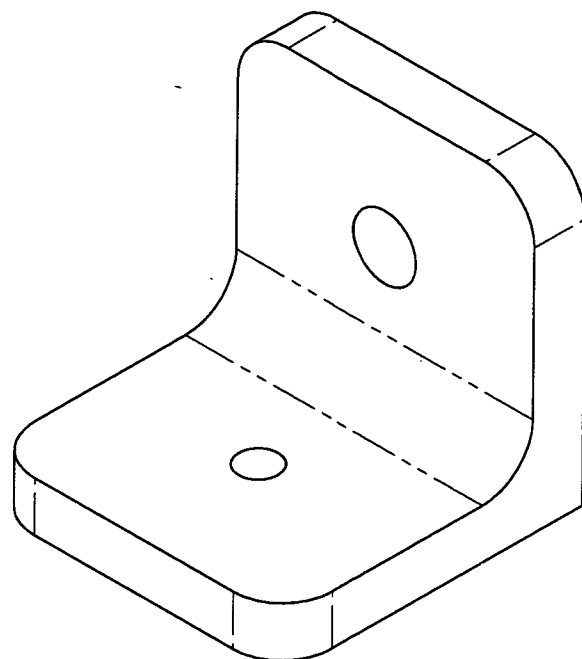
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>UC</i>	DRAWING NO.	REV. A
MFG. APPR.		D3741	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	2:1
DATE	08.02.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3741-1 ANGLE



DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CE	DRAWING NO. D3741	REV. B
MFG. APPR.	MS	SHEET 2 OF 2	
APPROVED	JP	TITLE	SCALE
DE APPR.	JA	ANGLE	NTS
DATE	08.03.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3741-1 ANGLE B

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125) B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED, SHEET 2 ZONE D5, Ø0.098 HOLE WAS Ø0.159, ZONE 6B 0.440 DIM WAS 0.450.	AJS	08.03.06
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	ND	D3741	SHEET 1 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	TH	ANGLE	NTS
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